

BLUE

Dart Aerospace Ltd.

23

Date: Wednesday, 5/16/2007 8:13:18 AM
User: Kim Johnston

Process Sheet



SPLIT - 1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 02.500 SUPPORT
Job Number	: 32374		
Estimate Number	: 11058		
P.O. Number	: N/A	Part Number	: D28921 <i>up</i>
This Issue	: 5/16/2007 S.O. No. : N/A	Drawing Number	: D2892 REV A
Print Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: A
Previous Run	: 28389	Material	: N/A
Written By	: <i>[Signature]</i>	Due Date	: 6/5/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	<i>10</i> Um: Each
Comment	: Est. C 02.11.26 Added P/O KJ		<i>6</i>

Conditional Product

Number: 



Seq. #:	Machine Or Operation:	Description:
1.0	PG	PURCHASING

Comment: PURCHASING
Issue P/O: *3795*
Description: D6104-003
Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104
Material release note required.
Blank size makes (2) D2891-1

C207105117 *(16)*

2.0	D6104003	17-4 SS Roundbar 3 25"OD
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Comment: Qty: 1,0000 Each(s)/Unit Total: 16,0000 Each(s)
Support

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Receive & Inspect for Transit Damage
Ensure Material Release Note is attached

[Signature] *07/06/05* *(16)*



4.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI LATHE
Turn blank for Haas as per Folio FA082

(6) *26 07/06/07*

5.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

(6) *26 07/07/08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/07/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Wednesday, 5/16/2007 8:13:18 AM
Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.500 SUPPORT

Job Number: 32374

Part Number: D28921

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

Machine as per Folio FA082

Tumble & Deburr

J.F.

07/07/05

(6)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07/07/05

(6)

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BG 07.07.17

(6)

9.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

10.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

stock unpacked

12

07.07.17

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(12)

07.07.18

Job Completion



07.07.18

DART AEROSPACE LTD		Work Order: 32374
Description: Ø2.500 Support		Part Number: D2892-1
Inspection Dwg: D2892 Rev. A		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2892 Rev. A/DSK077 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	51 ✓	62 ✓	73 ✓	84 ✓	By	Date
Lathe Section									
A	2.524	2.529		2.524	2.526	2.530	2.529		
B	3.702	3.722		3.703	3.710	3.707	3.712		
C	2.814	2.834		2.821	2.826	2.826	2.826		
D	0.718	0.738		0.727	0.732	0.732	0.730		
E	0.090	0.110		0.095	0.095	0.095	0.094		
F	2.714	2.734		2.728	2.724	2.728	2.726		
G	2.029	2.049		2.037	2.037	2.038	2.040		
H	3.214	3.234		3.227	3.227	3.227	3.226		
I	0.913	0.933		0.925	0.920	0.920	0.920		
J	0.022	0.042		0.032	0.032	0.032	0.032		
K	0.090	0.110		0.104	0.103	0.104	0.095		
L									
HAAS Section									
AA	0.115	0.135		0.132"		0.132"	0.132"		
AB	0.290	0.310		0.300"		0.300"	0.300"		
AC	0.040	0.060		0.044"		0.050"	0.044"		
AD	0.115	0.135		0.125"		0.127"	0.125"		
AE	0.240	0.260		0.250"		0.245"	0.245"		
AF	0.188	0.193	DT8706	0.188"		0.188"	0.188"		
AG	0.240	0.260		0.250"		0.250"	0.250"		
AH	1.126	1.146		1.146"		1.146"	1.142"		
AI	0.454	0.474		0.464"		0.463"	0.464"		
AJ	0.240	0.260		0.250"		0.250"	0.250"		
AK	0.053	0.073		0.053"		0.063"	0.053"		
AL	0.257	0.262	DT8683	0.257"		0.257"	0.257"		
AM	1.663	1.683		1.666"		1.676"	1.671"		
AN	0.053	0.073		0.063"		0.063"	0.063"		
AO	0.022	0.042		0.032"		0.032"	0.032"		
AP	2.779	2.789		2.788"		2.788"	2.788"		
AQ									
AR									
Accept/Reject									

Measured by: J.F.	Audited by: J.F.
Date: 07/07/18	Date: 07.07.17

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	J.F.

DART AEROSPACE LTD		Work Order: 32374
Description: Ø2.500 Support		Part Number: D2892-1
Inspection Dwg: D2892 Rev. A		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2892 Rev. A/DSK077 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9 ✓	10 2	11 3 ✓	12 4 ✓	By	Date
Lathe Section									
A	2.524	2.529		2.527	2.527	2.530	2.527		
B	3.702	3.722		3.710	3.709	3.707	3.704		
C	2.814	2.834		2.827	2.826	2.832	2.830		
D	0.718	0.738		0.728	0.735	0.733	0.735		
E	0.090	0.110		0.100	0.099	0.098	0.095		
F	2.714	2.734		2.727	2.727	2.727	2.727		
G	2.029	2.049		2.035	2.034	2.036	2.034		
H	3.214	3.234		3.228	3.226	3.227	3.224		
I	0.913	0.933		0.930	0.925	0.920	0.920		
J	0.022	0.042		0.032	0.032	0.030	0.030		
K	0.090	0.110		0.101	0.101	0.101	0.098		
L									
HAAS Section									
AA	0.115	0.135		0.133"	0.133"		0.132"		
AB	0.290	0.310		0.300"	0.300"		0.300"		
AC	0.040	0.060			0.042"		0.051"		
AD	0.115	0.135			0.127"		0.126"		
AE	0.240	0.260			0.251"		0.250"		
AF	0.188	0.193	DT8706		0.189"		0.189"		
AG	0.240	0.260			0.250"		0.250"		
AH	1.126	1.146			1.145"		1.146"		
AI	0.454	0.474			0.464"		0.463"		
AJ	0.240	0.260			0.250"		0.250"		
AK	0.053	0.073			0.053"		0.053"		
AL	0.257	0.262	DT8683		0.257"		0.258"		
AM	1.663	1.683			1.671"		1.670"		
AN	0.053	0.073			0.063"		0.063"		
AO	0.022	0.042			0.032"		0.032"		
AP	2.779	2.789			2.788"		2.788"		
AC									
AP									

Accept/Reject

Measured by: J.F.	Audited by: J.F.
Date: 07/07/05	Date: 07-07-17

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	J.F.

DART AEROSPACE LTD		Work Order:	32374
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892 Rev. A		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2892 Rev. A/DSK077 Rev. A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
Lathe Section									
A	2.524	2.529		2.528					
B	3.702	3.722		3.704					
C	2.814	2.834		2.824					
D	0.718	0.738		0.720					
E	0.090	0.110		0.095					
F	2.714	2.734		2.722					
G	2.029	2.049		2.039					
H	3.214	3.234		3.224					
I	0.913	0.933		0.920					
J	0.022	0.042		0.034					
K	0.090	0.110		0.095					
L									
HAAS Section									
AA	0.115	0.135		0.132					
AB	0.290	0.310		0.300					
AC	0.040	0.060		0.049					
AD	0.115	0.135		0.125					
AE	0.240	0.260		0.250					
AF	0.188	0.193	DT8706	0.188					
AG	0.240	0.260		0.250					
AH	1.126	1.146		1.142					
AI	0.454	0.474		0.463					
AJ	0.240	0.260		0.250					
AK	0.053	0.073		0.063					
AL	0.257	0.262	DT8683	0.258					
AM	1.663	1.683		1.670					
AN	0.053	0.073		0.063					
AO	0.022	0.042		0.032					
AP	2.779	2.789		2.787					
AQ									
AR									
Accept/Reject									

Measured by: J. J. J.	Audited by: J. J. J.
Date: 07/04/14	Date: 07-06-17

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	